

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025930**Date Inspected:** 12-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** John Pagliero**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 9E PP80 E4 (Interior)
2. 9E PP88 E4 (Interior)
3. 10E PP92 E3 (Exterior)

1. 9E PP80 E4 (Interior)

The QA inspector observed ABF welder Mike Jimenez ID# 4671 performing Shielded Metal Arc Welding (SMAW) in the 4G overhead position on Lifting Lug Hole (LLH) #3 located at 9E PP80 E4. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1110A Revision 1.

The parameters were recorded as (Amperes=132).

The QA inspector made subsequent observations throughout the shift to monitor quality and upon completion of the work the QA inspector observed QC perform a Visual Inspection (VT) on the weld and found no indications which the QA inspector verified and found the work to be visually acceptable.

The QA inspector noted that the work appeared to be in general conformance with the contract documents.

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### 2. 9E PP88 E4 (Interior)

The QA inspector observed Magnetic Particle Inspection (MT) performed by the QC inspector identified as Fred Von Hoff on Lifting Lug Holes (LLH) #1 and 3 located at 9E PP88 E4 on the interior of the OBG. The QA inspector monitored the QC to verify the weld and testing meet the requirements of the contract documents and upon completion of the testing, the QA inspector noted that no indications were observed and the work was found to be acceptable.

### 3. 10E PP92 E3 (Exterior)

The QA inspector observed ABF welder Salvador Sandoval ID# 2202 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole (LLH) #1 located at 10E PP92 E3. The QA inspector verified the fit up of the joint and found it to be satisfactory. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The parameters were recorded as (Amperes=132). The QA inspector made subsequent observations throughout the shift to monitor quality and upon completion of the work the QA inspector observed QC perform a Visual Inspection (VT) on the weld and found no indications which the QA inspector verified and found the work to be visually acceptable.

The QA inspector noted that the work appeared to be in general conformance with the contract documents.

#### Summary of Conversations:

At the beginning the shift the QA inspector met with QC inspector John Pagliero and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.



#### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Frey,Doug

Quality Assurance Inspector

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**Reviewed By:**      Levell,Bill

QA Reviewer